

**Work Order ID 65753**

Tuesday, January 25, 2011 10:24:37 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*1/4*Date: *1/25/25*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-541

CHG003

*N/A*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

DP

11-1-26

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BB

11/1/27

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: m116577/m111385

BE 11/1/31

4- grind fwd cap weld on top surface only

BE 11/1/31

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.  
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe  
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BE 11/02/01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Subtotal

X

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DP

11-2-2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE 1/24/02

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 &amp; QSI 015

A/R ☐ Sikaflex-291 ☒ 116040 ☐ 116040Sikaflex expire date: ☐ 11/01/20 ☐Start: ☐ 11/02/02 ☐ Time: ☐ 3:00 ☐Finish: ☐ 11/02/03 ☐ Time: ☐

(Adhere for 12 hours)

11/02/03 @ 8:55 AM1 0 BE 11/02/02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S11/02/03

HL

170

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

DP

11-2-3

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

BB

11/02/03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 3.060

0.00

4.40

Memo

1 0 BE 1/02/03

190



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod ☒ M111385

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

1 0 BE 1/03/03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/11/03/04

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/11/03/04

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1 BL 11-3-7

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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| Sequence ID/<br>Work Center ID          | Operation<br>Description                                                                                                                                                                                                                                                                                                                                                                                                                                       | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230<br><br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br><i>M115951.</i><br>Memo<br>START TIME: <i>1:25</i><br>OVEN TEMPERATURE: <i>220°</i><br>FINISH TIME: <i>1:55.</i>                                                                                                                                                                                                                                                                                               | 0.00<br><br>0.00     |         |        |              | <i>1</i>      | <i>BR</i>     | <i>11-3-7.</i>   |                |
| 240<br><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo                                                                                                                                                                                                                                                                                                                                                                                                                           | 0.00<br><br>0.00     |         |        |              | <i>1</i>      | <i>6</i>      | <i>11/03/11</i>  |                |
| 250<br><br>HandFinish<br>Hand Finishing | HandFinishing<br><br>Memo<br>✓ 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.<br>A/R <input type="checkbox"/> A <input type="checkbox"/> LPS-3 <input type="checkbox"/> <i>M114596</i><br>2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a<br>A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <i>21116046</i><br>Sikaflex expire date: <i>12/10/09</i> | 0.00<br><br>0.00     |         |        |              | <i>1</i>      | <i>6</i>      | <i>11/03/11</i>  |                |

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Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/11



Quality Control

Inspect Nut Plate & Inserts

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install wearpads & gaskets as per Dwg D3274.

✓ 2-Install ring as per Dwg D3274  
A/R ☐ Sikaflex-291 ☐ 11/16/04  
Sikaflex expire date: ☐ 11/09

✓ 3-Inspect for foreign objects as per QSI 024

✓ 4-Spray inside of tube on both sides of web with LPS-3  
A/R LPS-3 Batch: N/A

✓ 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.  
A/R ☐ Sikaflex-291 ☐ 11/16/04  
Sikaflex expire date: ☐ 11/09

1 p 90 2/03/14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 65753**

Tuesday, January 25, 2011 10:24:38 AM



Page 10

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

*S work*

Quality Control

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

*PDP 65282**Recy 3/15*

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

*11/3/15*

Quality Control

*mf**11-03-15*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries




Tuesday, January 25, 2011 10:24:45 AM

**Parent Item Name:** Replacement Skidtube

**Required Date: 1/31/2011**

**Required Qty: 1.00**

**Comments:** IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/<br>Item Name                                                                  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit     | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D2600-1-190<br> |                        | Manufactured  | No          |                     |                  | 110             | Each               | 46.0000        | 1               | 1            |               |                |        |
| Extrusion Round 3" 206                                                                           |                        |               |             |                     |                  |                 |                    |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                                                                  |                        |               |             | LG                  |                  |                 | 46                 |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 47575               |                  |                 | 2                  |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 59874               |                  |                 | 44                 |                |                 |              |               |                |        |
| D3285-1<br>     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 116.0000       | 1               | 1            |               |                |        |
| Cap                                                                                              |                        |               |             |                     |                  |                 |                    |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                                                                  |                        |               |             | LG                  |                  |                 | 116                |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 52511               |                  |                 | 68                 |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 52647               |                  |                 | 48                 |                |                 |              |               |                |        |
| D3282-041<br> |                        | Manufactured  | No          |                     |                  | 150             | Each               | 11.0000        | 1               | 1            |               |                |        |
| Float Web (206L/407)                                                                             |                        |               |             |                     |                  |                 |                    |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | <u>Location</u>     |                  |                 | <u>Loc Qty</u>     |                | <u>Loc Code</u> |              |               |                |        |
|                                                                                                  |                        |               |             | LG                  |                  |                 | 11                 |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 63389               |                  |                 | 1                  |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 65292               |                  |                 | 6                  |                |                 |              |               |                |        |
|                                                                                                  |                        |               |             | 65293               |                  |                 | 4                  |                |                 |              |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 25, 2011 10:24:45 AM

Page 2

Work Order ID: 65753

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

327.0000

12

12



Cross Bolt Spacer



BE 11/03/03

Location

Loc Qty

Loc Code

LG

327

58545

2

60652

4

61496

2

62889

11

63359

3

65317

305

12

D3275-1

Manufactured No

190

Each

113.0000

12

12



Crossbolt Spacer



BE 11/03/03

Location

Loc Qty

Loc Code

LG

113

53453

8

62399

1

63546

19

65295

85

8

CR3212-4-03

Purchased No

250

Each

1,869.000

2

2



Cherry Rivet



HL 11/03/11

Location

Loc Qty

Loc Code

ST311

1869

110153

35

111359

5

112314

2

114436

448

114450

33

114859

1346

M110139

X2

Tuesday, January 25, 2011 10:24:46 AM

Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, January 25, 2011 10:24:46 AM

Work Order ID: 65753

Parent Item: D206-642-541


Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011


Required Date: 1/31/2011

Start Qty: 1.00


Required Qty: 1.00

D3415-041 Manufactured No 250 Each 33.0000 1  
  
 Nut Plate 11/03/11

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| ST056        | 33      |          |
| <u>33842</u> | 33      |          |

CCR264SS3-3 Purchased No 250 Each 186.0000 2  
  
 Cherry Rivet X1  
2 11/03/11

| Location      | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST311         | 186     |          |
| 112314        | 4       |          |
| 113539        | 44      |          |
| <u>113973</u> | 138     |          |

ALS4-1032-130 Purchased No 250 Each 927.0000 78  
  
 Insert X2  
78 11/03/11

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| PKG11    | 500     |          |
| 114723   | 500     |          |
| ST281    | 292     |          |
| 116049   | 292     |          |
| ST282    | 96      |          |
| 110511   | 10      |          |
| 115911   | 86      |          |
| ST381    | 39      |          |
| 114654   | 39      |          |

X116864 X78

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 25, 2011 10:24:46 AM

Work Order ID: 65753

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011



Required Date: 1/31/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-15      Manufactured      No      270      Each      18.0000      1      1  
  11103111  
 Gasket



| Location     | Loc Qty | Loc Code        |
|--------------|---------|-----------------|
| FP           | 1       |                 |
| 56055        | 1       |                 |
| FP011        | 16      |                 |
| <u>63568</u> | 16      | X1              |
| FP11         | 1       |                 |
| 59238        | 1       | <u>11103111</u> |

D3536-23      Manufactured      No      270      Each      9.0000      1      1  
  11103111  
 Gasket

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP011        | 9       |          |
| <u>63570</u> | 9       | X1       |

D3536-35      Manufactured      No      270      Each      4.0000      1      1  
  11103111  
 Gasket

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP012    | 4       | B65573   |
| 58683    | 1       | X1       |
| 63579    | 3       |          |

D3536-39      Manufactured      No      270      Each      15.0000      1      1  
  11103111  
 Gasket

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP012        | 14      |          |
| <u>63578</u> | 14      | X1       |
| FP12         | 1       |          |
| 58215        | 1       |          |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 25, 2011 10:24:47 AM

Work Order ID: 65753

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Manufactured No

270 Each

11.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

11

63569

11

21

D3535-35

Manufactured No

270 Each

5.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

5

63577

5

1355426

21

D3535-39

Manufactured No

270 Each

21.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

8

62945

8

FP-18

13

64076

13

21

D3535-23

Manufactured No

270 Each

13.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FP021

12

63571

12

21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 25, 2011 10:24:47 AM

Work Order ID: 65753

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270

Each

6.0000

1

1



Wearpad

Location

Loc Qty

Loc Code

FP17

6

B65929

x1

62705

6

D3537-1 Manufactured No

270

Each

92.0000

9

9



Wearpad

Location

Loc Qty

Loc Code

FP017

92

63997

20

64424

72

AN960C10L NAS1149C0332 Purchased No

270

Each

25.0000

80

80



washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

AN960C416 NAS1149C0463 Purchased No

270

Each

29.0000

1

1



washer

Location

Loc Qty

Loc Code

ST346

29

100993

29

M1115358

x1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, January 25, 2011 10:24:47 AM

Work Order ID: 65753

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

1,309.000 2 2



Phenolic Washer



110314

Location

Loc Qty

Loc Code

ST077

1309

42329

10

52505

299

64177

1000

x2

AN3C4A Purchased No

270 Each

1,172.000 80 80



BOLT



110314

Location

Loc Qty

Loc Code

ST350

1172

115300

25

116075

947

116590

200

1116704

1117010

x 16

x 66

AN4C5A Purchased No

270 Each

447.0000 1 1



BOLT



110314

Location

Loc Qty

Loc Code

ST346

447

110552

1

112243

446

v1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 25, 2011 10:24:48 AM

Work Order ID: 65753

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

84.0000

1

1



Aft Cap



1103114

Location

Loc Qty

Loc Code

FP-4

13

57332

13

FP6

17

52663

3

62678

12

63633

2

Return 2010

54

62678

54

X

D3413-1

Manufactured No

270

Each

33.0000

1

1



Ring



1103114

Location

Loc Qty

Loc Code

ST420

17

62961

17

ST473

16

51586

1

53446

5

65294

10

X

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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|                        |                         |                                              |                        |
|------------------------|-------------------------|----------------------------------------------|------------------------|
| DESIGN<br>CP           | DRAWN BY<br>PH          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3274                         | REV. D<br>SHEET 1 OF 4 |
| DATE<br>06.12.19       |                         | TITLE<br>SKIDTUBE ASSEMBLY                   | SCALE<br>NTS           |
| A                      | 04.03.15                | NEW ISSUE                                    |                        |
| B                      | 04.08.09                | MOVE SADDLE HOLE: 42.14 WAS 42.76            |                        |
| C                      | 05.03.16                | ADD -043; NEW INSERTS                        |                        |
| D                      | 06.12.19                | NEW INSERTS, SS WEARSHOE + GASKET            |                        |

| Qty<br>-041 | Qty<br>-043 | Part Number   | Description                                             |
|-------------|-------------|---------------|---------------------------------------------------------|
| X           |             | D3274-041     | SKIDTUBE ASSEMBLY                                       |
|             | X           | D3274-043     | SKIDTUBE ASSEMBLY                                       |
| 1           | 1           | D2600-1-240   | EXTRUSION                                               |
| 1           | 1           | D2646         | AFT CAP                                                 |
| 12          | 12          | D2649         | CROSS BOLT SPACER                                       |
| 12          | 37          | D3275-1       | CROSS BOLT SPACER                                       |
| 1           | 1           | D3282-041     | FLOAT WEB                                               |
| 1           | 1           | D3285-1       | CAP                                                     |
| 1           | 1           | D3413-1       | RING                                                    |
| 1           | 1           | D3415-041     | NUT PLATE                                               |
| 1           | 1           | D3535-15      | WEARSHOE                                                |
| 1           | 1           | D3535-23      | WEARSHOE                                                |
| 1           | 1           | D3535-35      | WEARSHOE                                                |
| 1           | 1           | D3535-39      | WEARSHOE                                                |
| 1           | 1           | D3536-15      | GASKET                                                  |
| 1           | 1           | D3536-23      | GASKET                                                  |
| 1           | 1           | D3536-35      | GASKET                                                  |
| 1           | 1           | D3536-39      | GASKET                                                  |
| 9           | 9           | D3537-1       | WEARPAD                                                 |
| 1           | 1           | D3537-3       | WEARPAD                                                 |
| 78          | 78          | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80          | 80          | AN3C4A        | BOLT                                                    |
| 1           | 1           | AN4C5A        | BOLT                                                    |
| 1           | 1           | AN960C416     | WASHER                                                  |
| 80          | 80          | AN960C10L     | WASHER                                                  |
| 2           | 2           | CCR264SS3-3   | RIVET                                                   |
| 2           | 2           | CR3212-4-03   | RIVET                                                   |
| 2           | 2           | NAS1515H3L    | WASHER                                                  |

**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 65733

P/11-0125

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

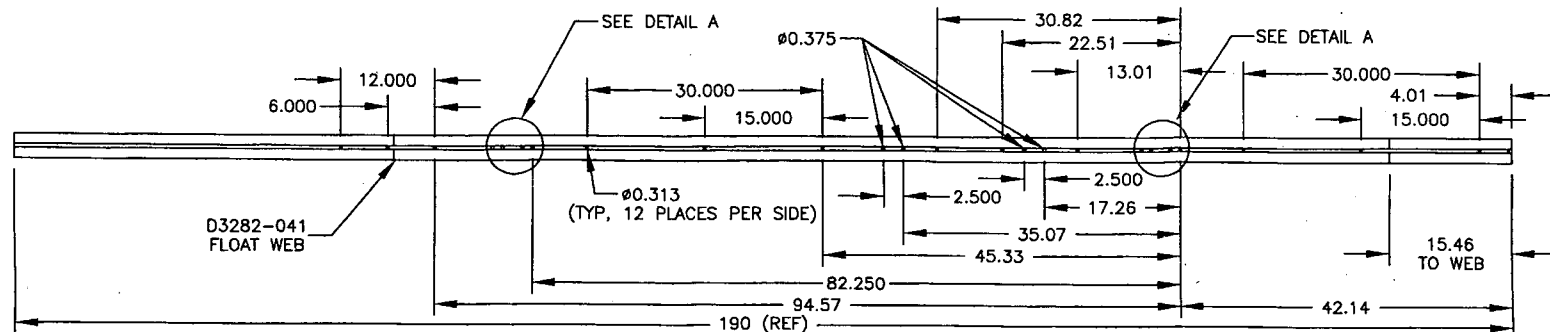
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

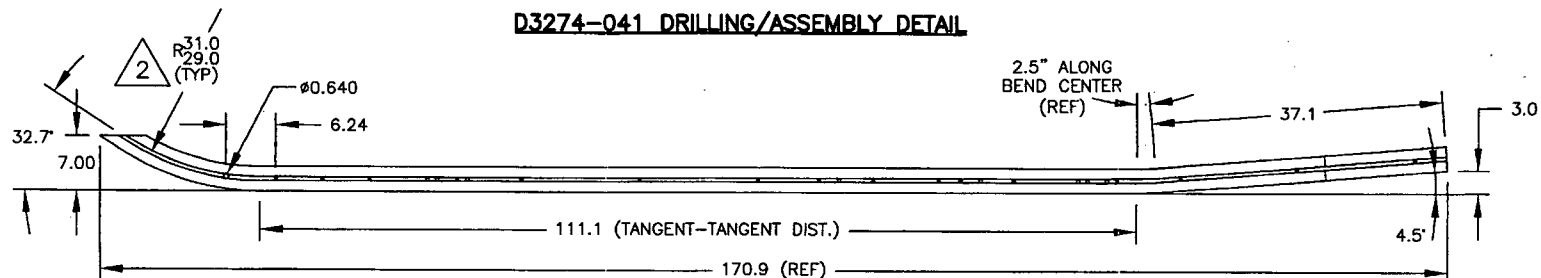
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE;** Date & initial all entries

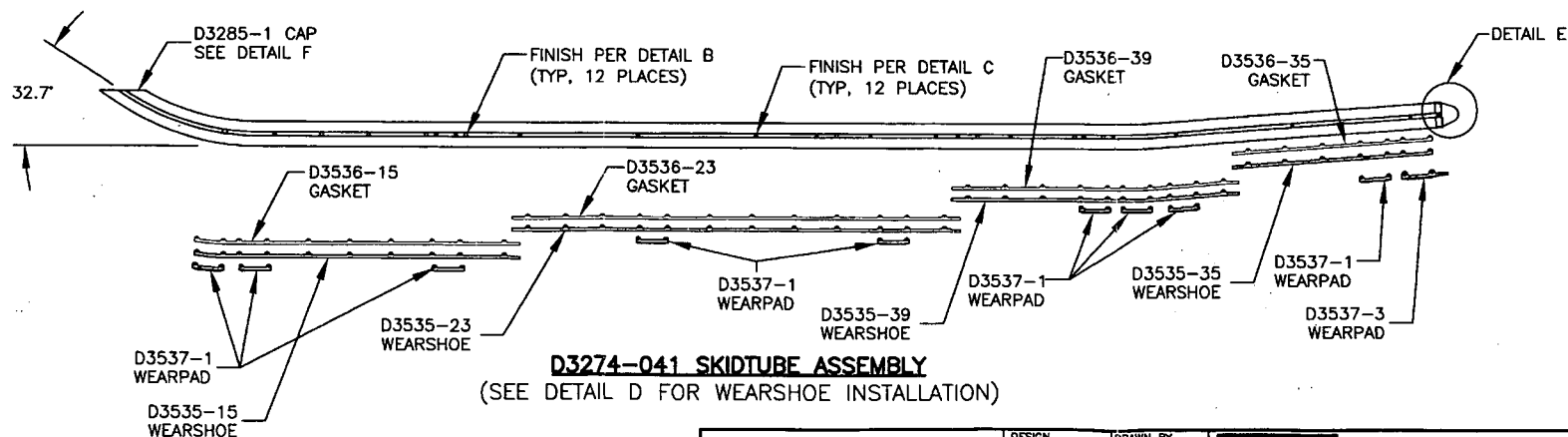
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

u/o 65753

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|                                              |          |        |          | D3274                                        | SHEET 2 OF 4 |
| DATE                                         |          |        |          | TITLE                                        | SCALE        |
| 06.12.19                                     |          |        |          | SKIDTUBE ASSEMBLY                            | 1:15         |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

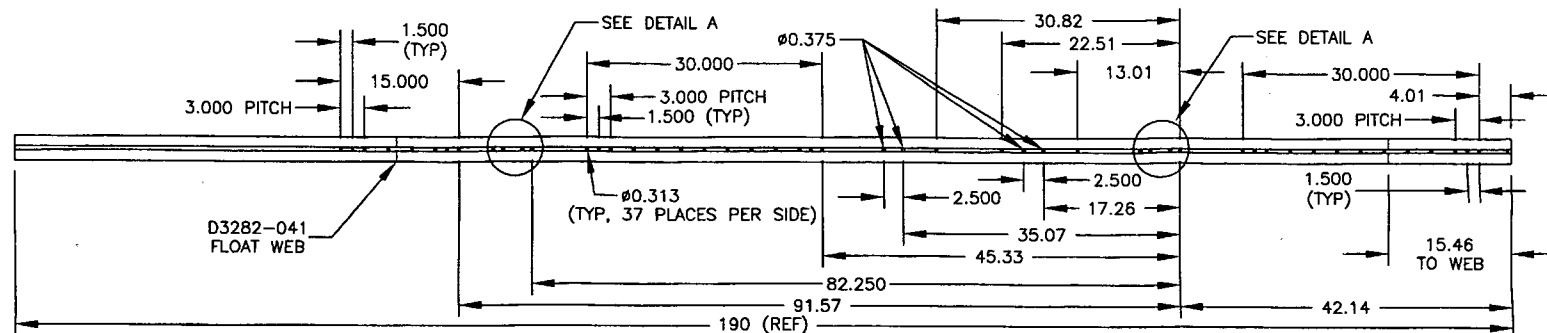
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

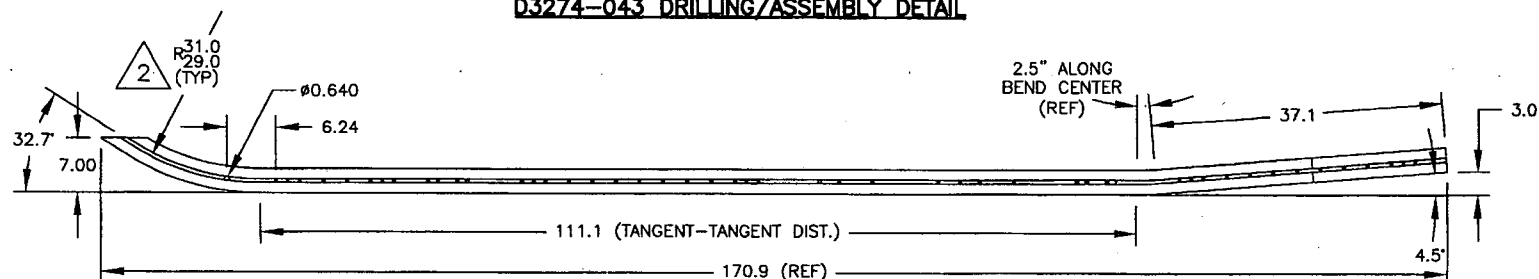
**NOTE:** Date & initial all entries



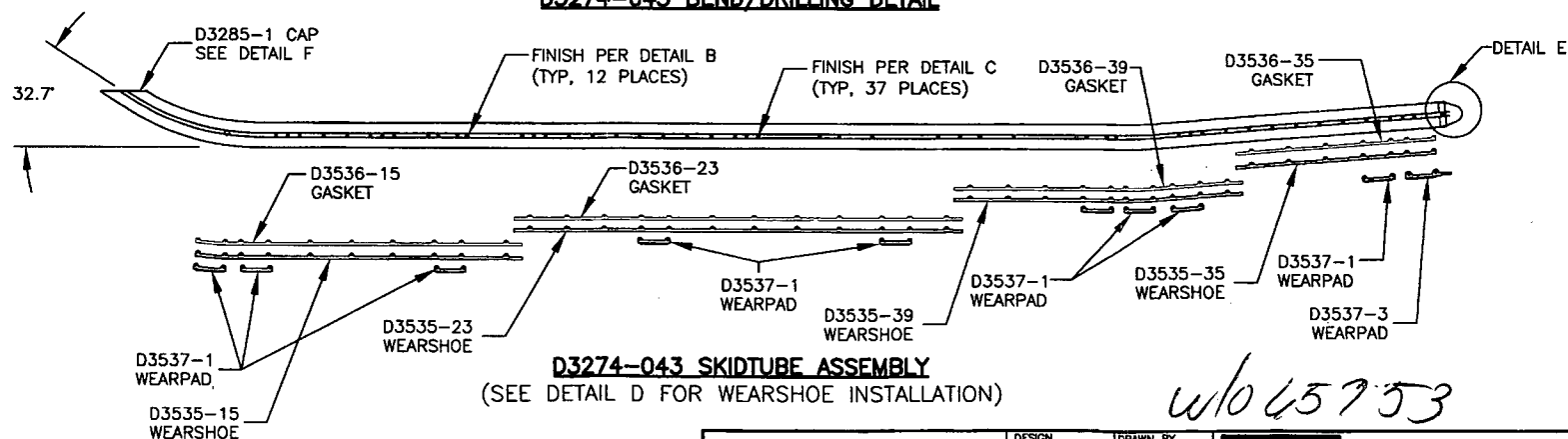
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

|                                                                                                                                                                                                                                     |  |          |          |                               |              |
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|                                                                                                                                                                                                                                     |  | #        | #        | D3274                         | SHEET 3 OF 4 |
|                                                                                                                                                                                                                                     |  | DATE     |          | TITLE                         | SCALE        |
|                                                                                                                                                                                                                                     |  | 06.12.19 |          | SKIDTUBE ASSEMBLY             | 1:15         |

w/045753

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

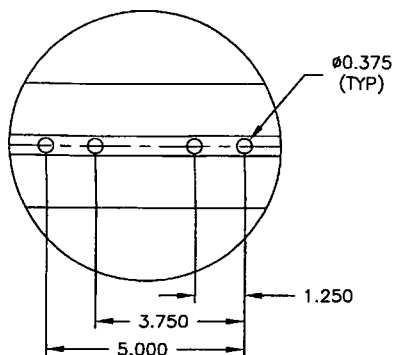
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

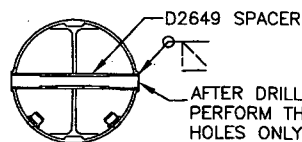
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# **DETAIL A: DRILL DETAIL**

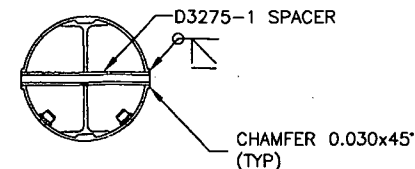


# **DETAIL B** FOR 0.375 HOLES ONLY

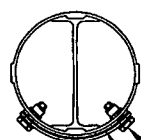


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY



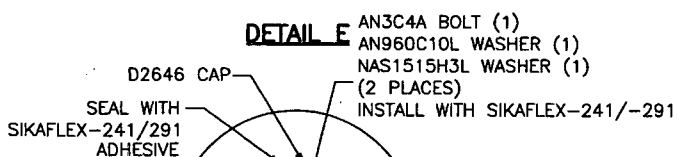
# **DETAIL D**



- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

# **DETAIL E**

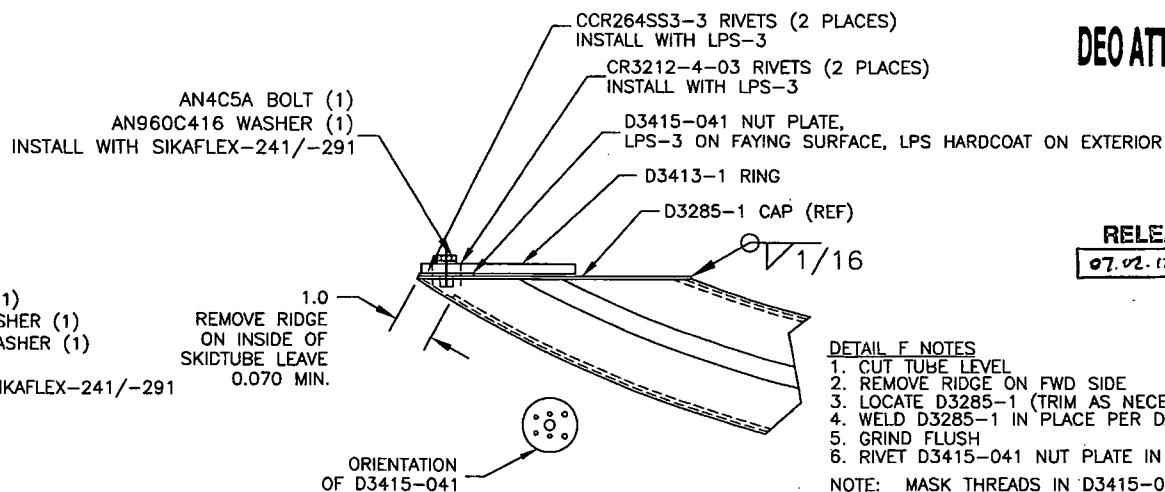


0.208 (2 PLACES)  
DRILL PRIOR TO INSTALLING  
D2646 CAP

BORE OUT END OF SKIDTUBE  
TO 0.75 DEPTH AND 0.070 WALL

0.400

# **DETAIL F: END FINISHING DETAIL**



# **DETAIL F NOTES**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**DEO ATTACHED**

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| CHECKED | #        | APPROVED | #                 | DRAWING NO. D3274                    | SHEET 4 OF 4 |
| DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | SCALE                                | 1:3          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

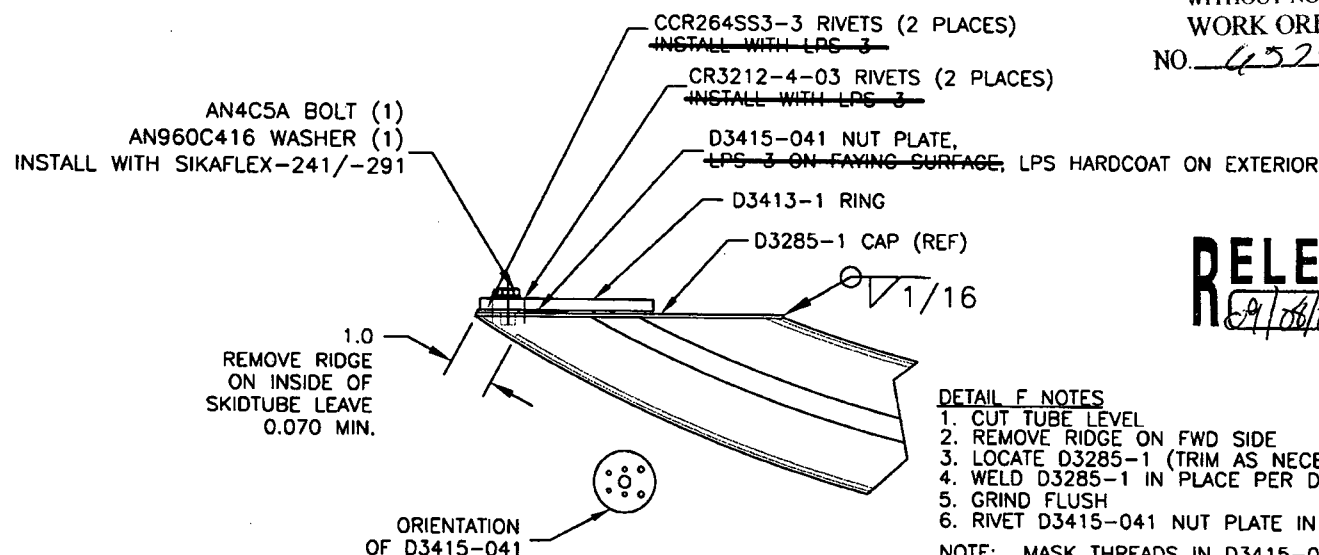
|                      |                               |                                  |                                              |  |                                |                           |              |
|----------------------|-------------------------------|----------------------------------|----------------------------------------------|--|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3274 | TITLE<br>SKIDTUBE ASSEMBLY    | REV. D                           | DART AEROSPACE USA, INC<br>ENGINEERING ORDER |  | D.E.O. NO.<br>D3274-D-1        | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br><i>CP</i>   | CHECKED<br><i>[Signature]</i> | MFG. APPR.<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>               |  | DE APPR.<br><i>[Signature]</i> |                           |              |
| DATE<br>09.06.17     | DATE<br>09.06.23              | DATE<br>09/06/23                 | DATE<br>09/06/23                             |  | DATE<br>09.06.23               |                           |              |

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



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WORK ORDER  
NO. 45753

**RELEASED**  
09/06/23

#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries,

NO. 242

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 65212  
Part number: 206-642-341  
Description: 206 Skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Evans Date of Test Coupon 11-01-13

Welder Barclay Elliott Date of Test Coupon 11-01-13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld